

DART
AEROSPACE

S012872



Long Basket Base Assembly, 350

Dart Aerospace Ltd.

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PART NO:

D3913-041

Revision:

Operation:

Start up Operation

Change No:

Mfg Date: 11/23/17

Job No: 167640



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D3913-041
Job Sheet 167640



Part No: D3913-041 Job Qty: 1 ea
Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/3/17

Job Tracking No:

Due Date: 11/30/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/29/17	0.00	0.00	Start Up Large Fab2		<i>N.M.L 17-11-22</i>
100	Large Fab	1 pcs		11/29/17	0.00	10.00	Large Fab 1		<i>N.M.L 17-11-23</i>
110	QC	1 pcs		11/29/17	0.00	0.00	QC9		<i>17-11-24</i>
120	QC	1 pcs		11/29/17	0.00	0.00	QC5		<i>17-11-24</i>
125	HandFinish	1 pcs		11/29/17	0.00	0.29	HandFinish2		<i>17-11-30</i>
130	Powdercoat	1 pcs		11/29/17	0.00	0.93	Powdercoat2		<i>17-12-01</i>
140	QC	1 pcs		11/29/17	0.00	0.00	QC3		<i>17-12-04</i>
150	HandFinish	1 pcs		11/30/17	0.00	0.50	HandFinish4		<i>17-12-04</i>
160	QC	1 pcs		11/30/17	0.00	0.00	QC5		<i>17-12-04</i>
170	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging3		<i>17-12-04</i>
180	QC21-SA	1 Ea		11/30/17	0.00	0.00	QC21		<i>21 DEC 14 2017</i>

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M136647 START: 7:30 O.V.T: 375° FINISH: 7:45.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D25815 0058342	2	12	0	0
	D3913-1	1	14	0	0
	D3913-15 F161938	1	9	0	0
	D3913-3	1	16	0	0
	D3913-7 5009710	2	8	0	0
	D3913-9 5010881	1	7	0	0
	D3916-041 5010882	2	8	0	0
	D3916-5	3	17	0	0
	D4016-1 5009181	32	4	0	0
	D4017-7	3	52	0	0
	D4017-9 5009723	2	8	0	0
	D4020-11	2	0	0	0
	D4021-1 F166089	3	24	0	0
	D4034-041	1	6	0	0
	D4034-043 5008661	1	0	0	0
	D4672-1 F166089	2	1	0	0
	M304EX0.75-16F 5009863	33	572	0	0
150-HandFinish	AN3-10A 5014736	6	252	0	0

FM137412.40

D2931 F 86435-1	2	1,336	0	0
D4021-5 F 166287	2	18	0	0
MS20600-AD4W3	2	313	0	0
MS21042L3 5016501	6	1,117	0	0
NAS1149F0332P 5000570	12	2,930	0	0

Part Specifications

Specifications could not be found.

Plex 11/3/17 2:42 PM dart.poulin.mario